

Date: Thursday, 22/01/2009 7:52:26 AM
 User: Melanie Fauteux

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 90 DEGREE BLADE SUPPORT ASSY
Job Number : 45022	
Estimate Number : 13386	
P.O. Number :	Part Number : PB674300167
This Issue : 22/01/2009 S.O. No. :	Drawing Number : B6743001 PAGE 29
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : B1
Previous Run : 41510	Material :
Written By :	Due Date : 28/01/2009 Qty: 14 Um: Each
Checked & Approved By : <u>CMF 09-01-22</u>	
Comment : Est Rev:A 08-06-19 new issue DD verified by:ec Est Rev:B 08-09-23 remove alodine and QC3 DD verified by:EC	

Additional Product

Job Number:



Seq. #: Machine Or Operation:

Description:

1.0 M6061T6S090 6061-T6 .090 Sheet



Comment: Qty.: 0.6241 sf(s)/Unit Total: 8.7377 sf(s)
 6061-T6 .090 Sheet
 batch: 109184 B9-2-2

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
 1-Cut as per Dwg B67-43001-147
 Dwg Rev: B1 B9-2-2
 Prog Rev: B1
 2-Deburr if necessary B9-2-2

(15)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

509/02/02 415

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: Form as per dwg B67-43001

SB 29/02/10

15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/02/10 (15)

7.0

PB6743001149

(15 LH + 15 RH) Side Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 28.0000 Each(s)

Side Plate B 41560

09/02/09 (15)

12.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: Weld assembly as per dwg B67-43001

09-02-11 15

13.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 09-02-12 (15)

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/02/10 (15)

18.0

MS21075L3

Nutplate



Comment: Qty.: 6.0000 Each(s)/Unit Total : 84.0000 Each(s)

Nutplate M 110363

09/02/09 15

20.0

MS20426AD34

RIVET



Comment: Qty.: 12.0000 Each(s)/Unit Total : 168.0000 Each(s)

RIVET M 104374

09/02/09 15

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: Assemble as per dwg B67-43001

09/02/10 (15)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/02/10
15 LH
15 RH

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

ST 437

JS 09/02/12 KRS

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/13 JA

Job Completion



MF 09-02-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

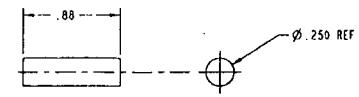
PB 674320i-67

X	First Article	X	Prototype
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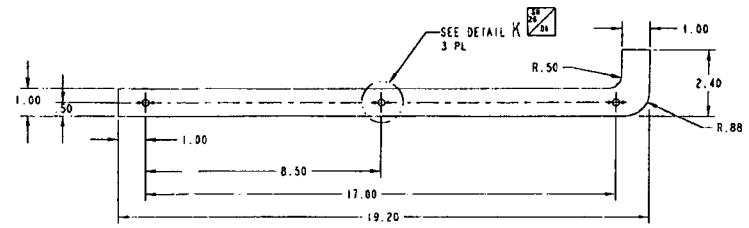
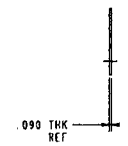
Measured by: B	Audited by: S	Prototype Approval: 1
Date: 9-2-2	Date: 09/01/07	Date: 12



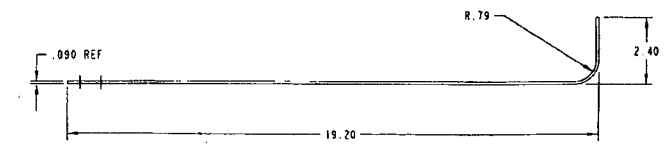
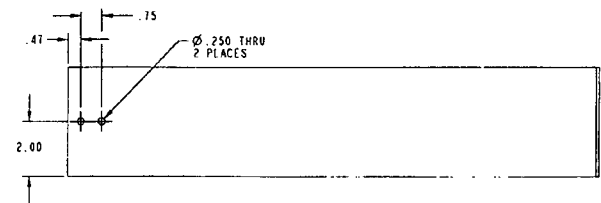
REFERENCE ONLY **RELEASED**
06 07 20



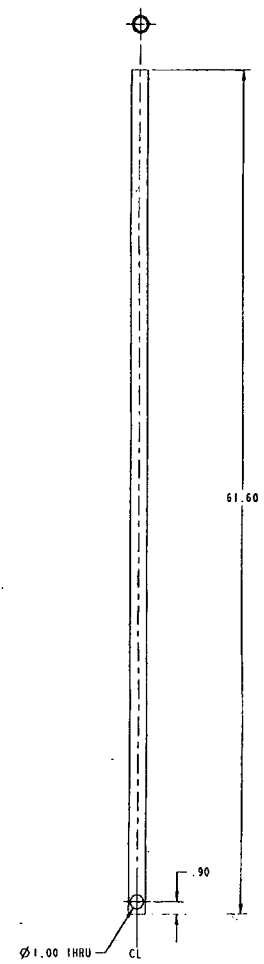
① -155 PIN
MATL: .250 RND, 303 SS
AMS5640 COND A
SCALE 2.000



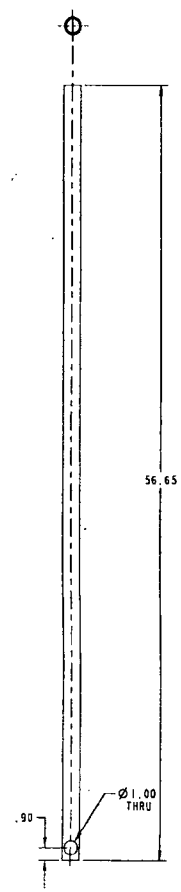
① -149 SIDE PLATE
MATL: .090 THK, 6061-T6, QQ-A 250/11
SCALE 0.500



② -147 SUPPORT PLATE
MATL: .090 THK, 6061-T6, QQ-A 250/11
SCALE 0.500



① -255 INNER TUBE
MATL: 1.25 OD X .125 WALL, 6061-T6, WW-T-100/5
SCALE 0.250



① -259 INNER TUBE
MATL: 1.25 OD X .125 WALL, 6061-T6, WW-T-100/5
SCALE 0.250

4822

PREMIER AVIATION, INC.			
2002 Aviation Parkway, Grand Prairie, Texas 76050			
DATE	CODE IDENT NO	DWG NO	REV
01/05/88	867 43001	81	
SCALE	BY	SHEET	24 OF 25

ORIGINAL